

Date: Wednesday, 2/15/2006 3:46:04 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
<b>Job Number</b> : 25829	
<b>Estimate Number</b> : 10530	
<b>P.O. Number</b> : <i>NA</i>	<b>Part Number</b> : D2571
<b>This Issue</b> : 2/15/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D2571 REV <i>DE</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : <i>N/A</i>
<b>First Issue</b> : <i>NA</i> <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : <i>DE</i> <i>UP 06.02.16</i>
<b>Previous Run</b> : 25828	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>See Comment Below</i>	<b>Due Date</b> : 3/15/2006 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>06.02.16</i>	
<b>Comment</b> : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2571  
 Ensure that grain is along 7.75" length  
 Batch No: *B24070*

*BG FOR EO / S.G. 06/02/21 10*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. *25829* Double check by: *BG*

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

*BG FOR EO / S.G. 06/02/21 10*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2571 & D2572

*BG FOR EO / S.G. 06/02/25 10*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*BG FOR EO / S.G. 06/02/25 10*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 10/03/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 2/15/2006 3:46:04 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25829

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

36

06.02.27

10

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-03-01

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-03-06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MA

06 03 06

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 31478

C 206103107

10

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/08

Job Completion



U 06-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	25829
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.747	1.746		
C	3.495	3.505		3.495	3.496	3.498	3.497		
D	1.745	1.755		1.746	1.746	1.747	1.746		
E	7.990	8.010		8.008	8.006	8.005	8.005		
F	0.490	0.510		0.494	0.504	0.503	0.500		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.498	0.499	0.500		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.566	0.563	0.565	0.564		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.494	1.493	1.493	1.493		
N	2.495	2.505		2.497	2.495	2.499	2.497		
O	3.869	3.879		3.871	3.870	3.872	3.872		
P	0.115	0.135		0.122	0.125	0.128	0.125		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.246	0.249	0.244	0.244		
S	0.115	0.135		0.122	0.125	0.126	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.239	0.236	0.235		
W	0.115	0.135		0.120	0.123	0.122	0.123		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.766		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.630	0.629	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.246	0.240	0.245		
AE	1.375	1.395		1.389	1.391	1.390	1.388		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.245	0.248	0.248		
AI	2.000	2.020		2.003	2.002	2.004	2.003		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	Ep
Date:	06/02/23

Audited by:	gm
Date:	06/02/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

1.323  
06/02/24

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>25829</b>
<b>Description: Saddle, Fwd Outboard</b>	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg: D2571 Rev. E</b>		<b>Page 1 of 1</b>

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B	1.745	1.755		1.746	1.747	1.747	1.747		
C	3.495	3.505		3.497	3.499	3.499	3.499		
D	1.745	1.755		1.746	1.747	1.747	1.747		
E	7.990	8.010		8.003	8.005	8.003	8.003		
F	0.490	0.510		0.499	0.496	0.499	0.499		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.499	0.499	0.499		
J	1.174	1.184		1.177	1.175	1.174	1.174		
K	0.558	0.578		0.566	0.566	0.568	0.568		
L	1.174	1.184		1.177	1.175	1.177	1.177		
M	1.490	1.500		1.493	1.493	1.493	1.494		
N	2.495	2.505		2.497	2.497	2.497	2.498		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		0.121	0.122	0.124	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.248	0.247	0.248	0.244		
S	0.115	0.135		0.125	0.123	0.128	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.241	0.233	0.234	0.234		
W	0.115	0.135		0.124	0.122	0.127	0.127		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.627	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.242	0.242	0.243		
AE	1.375	1.395		1.385	1.390	1.387	1.385		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.250	0.243	0.244	0.245		
AI	2.000	2.020		2.000	2.004	2.002	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EN / S. G
Date:	06/02/25

Audited by:	RG
Date:	06.02.27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
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G	0.257	0.262	DT8683	0.257	0.257				
H	0.375	0.380	DT8684	0.375	0.375				
I	0.490	0.510		0.495	0.499				
J	1.174	1.184		1.174	1.177				
K	0.558	0.578		0.568	0.568				
L	1.174	1.184		1.177	1.177				
M	1.490	1.500		1.494	1.494				
N	2.495	2.505		2.499	2.498				
O	3.869	3.879		3.873	3.870				
P	0.115	0.135		0.125	0.125				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		0.250	0.245				
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Z	0.352	0.372		0.360	0.366				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.627	0.628				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.250	0.250				
AE	1.375	1.395		1.379	1.379				
AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		0.250	0.250				
AH	0.240	0.260		0.250	0.250				
AI	2.000	2.020		2.008	2.008				
AJ	0.023	0.043		0.030	0.030				
Accept/Reject									

Measured by:	J. G.
Date:	06/02/25

Audited by:	36
Date:	06.02.27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

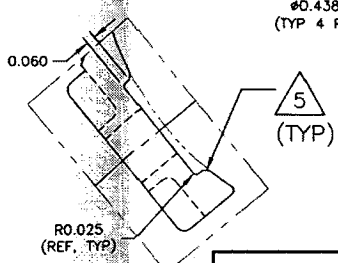
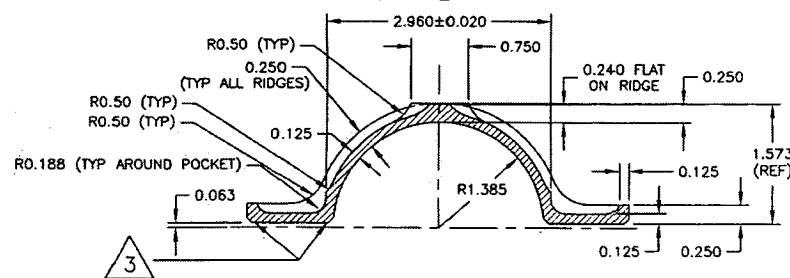
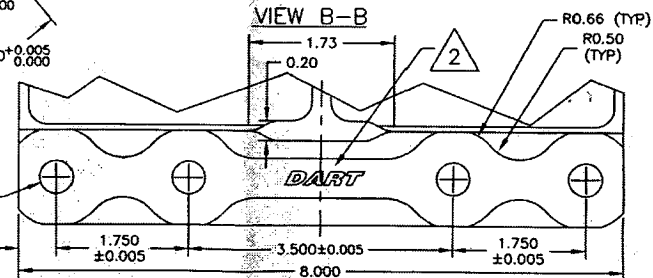
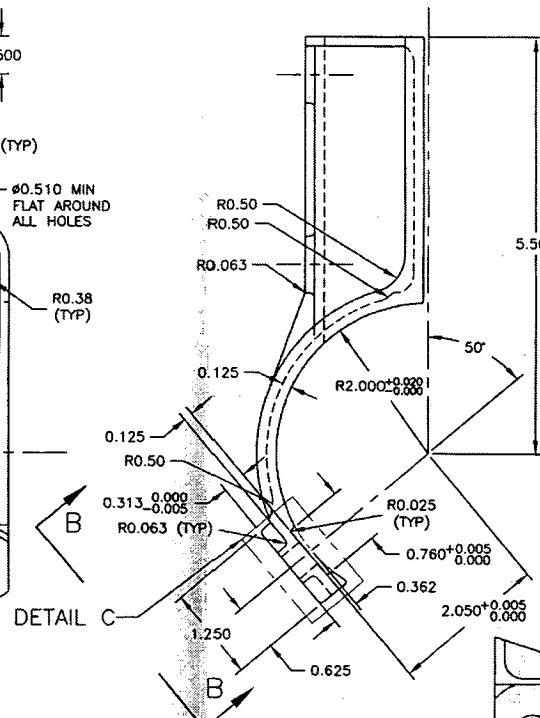
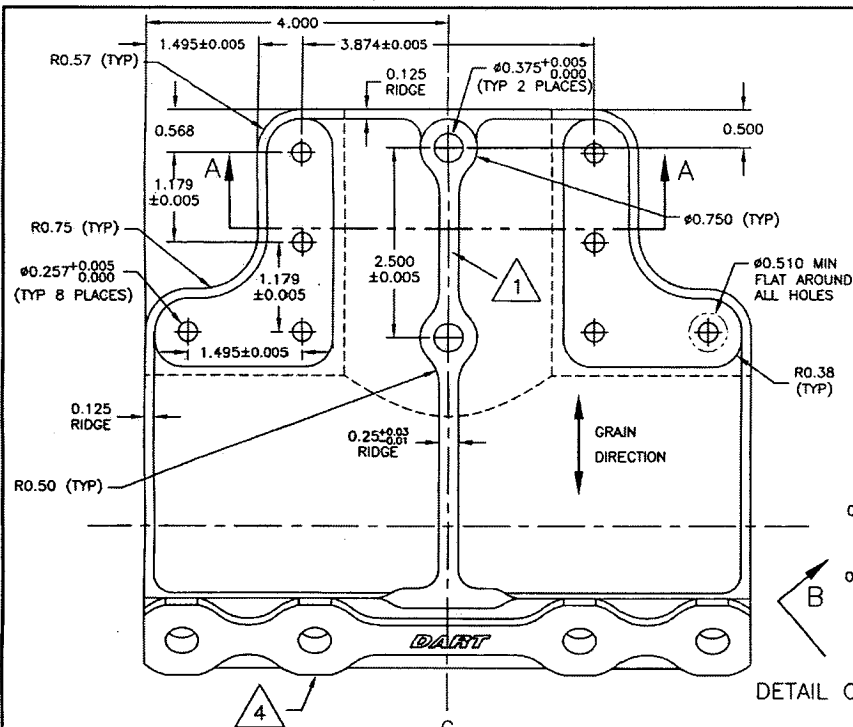
05-12-06

# NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
 QSI 005: 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E



SECTION A-A

DETAIL C  
 SCALE 4:3

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E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2571
		TITLE OUTER FWD SADDLE
		SCALE 2:3

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